

Date: Tuesday, 8/1/2006 11:30:58 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SPACER BUSHING
Job Number	28073			
Estimate Number	10826			
P.O. Number	N/A		Part Number	D23273
This Issue	8/1/2006	S.O. No. : N/A	Drawing Number	D2327 REV C
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type : MACHINED PARTS	Drawing Revision	C
Previous Run	27051		Material	N/A
Written By			Due Date	8/8/2006
Checked & Approved By		7/06 08.01	Qty:	50
Comment	Est. F 05.14.02	Removed 303 SS KJ/EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0375	304 SS ROUND BAR
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Comment: Qty.: 0.1641 f(s)/Unit	Total : 8.2058 f(s)
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Inventory

Material: AISI 303 Round Bar Ø0.375"

(M304R0.375)

Batch: M100817

5.G 06/08/27

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Deburr

5.G 06/08/27

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.G 06/08/27

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.G 06.08.27

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST31

5.G 06/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: Date: 06/09/01

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Tuesday, 8/1/2006 11:30:58 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 28073

Part Number: D23273

Job Number:



Seq. #: Machine Or Operation:

6.0 DC

DOCUMENT CONTROL



50

Comment: DOCUMENT CONTROL

Inspection Level 21



06/08/01

Job Completion



U 06-08-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	28073
Description: Spacer Bushing	Part Number:	D2327-3
Inspection Dwg: D2327	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

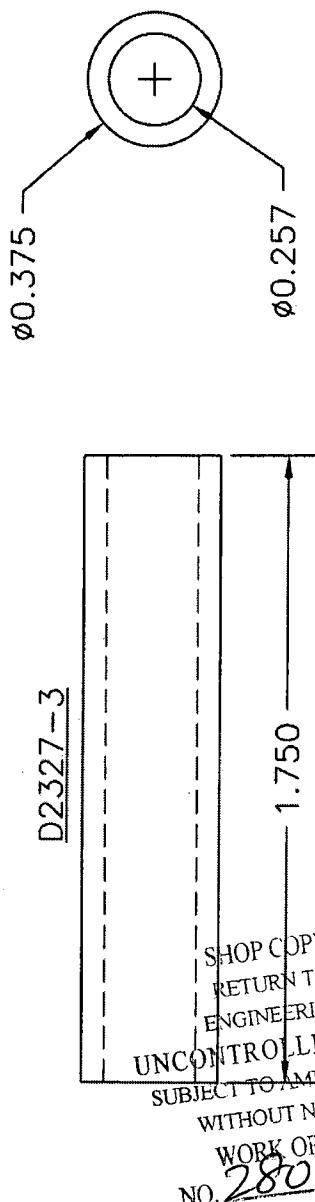
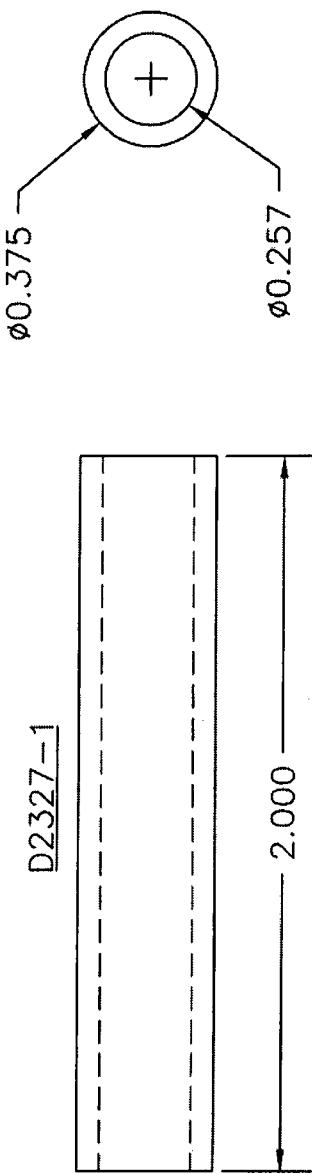
Measured by:	J.G	Audited by:	SA	Prototype Approval:	N/A
Date:	06/08/27	Date:	26/08/27	Date:	21/10

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	PT

DART

COPY ISSUED

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2327	REV. C SHEET 1 OF 1
DATE 03.05.13		TITLE SPACER BUSHING	SCALE 2:1
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	

RELEASED
03.05.21 *[Signature]*

NOTE:

1) MATERIAL: Ø0.375 AISI 303 ROUND BAR (REF. DART SPEC. M303R0.375) OR Ø0.375 AISI 304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TRO.375W.065)

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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